

Work Order ID 72576

Tuesday, August 02, 2011 1:38:58 PM



Page 1

Item ID: D3190-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Chafing Shield

Start Date: 8/2/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-08-17

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3190 | Rev A | | | | | | | | |
| 100 | | 0.00 | | | | | | | |
| | | | | | | | | | |
| Waterjet | Memo | 0.00 | | | | | | | |
| FLOW CNC Waterjet | CUT AS PER DWG DWG REV: A PROG REV: A | | | | | | | | |
| 105 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
| | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 106 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

B11-8-17



B11-8-17

S u l u s 118

counted
+35

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 72576

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|-------------------------------|
| 107 | SHEAR | 0.00 | | | | | | | |
| | | | | | | | | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | Roll as per Dwg D3190 | | | | | | | | |
| | | | | | | | | | <i>8/11/08/18</i> (35) |
| 110 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | <i>counted</i> (35) |
| 120 | Identify as per dwg & Stock Location: <i>x tube</i> | 0.00 | | | | | | | |
| | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | <i>11 09 15</i> (35) |

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Work Order ID 72576

Tuesday, August 02, 2011 1:38:58 PM



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Revision ID:

Stop



Item Name: Chafing Shield

Start Date: 8/2/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/15
MK
11-09-15

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, August 02, 2011 1:39:05 PM

Page 1

Work Order ID: 72576



Parent Item: D3190-1



Parent Item Name: Chafing Shield



Start Date: 8/2/2011

Required Date: 8/8/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A ☐ 03.05.26 ☐ New issue ☐ KJ/RF ☐

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|--------------|---------------|----------------|--------|
| M304S25GA  304/316 .020" Sheet | | Purchased | No | | | 100 | sf | 128.0000 | 0.2153 | 2.266316 | 8, | | |
| | | | | | | | | |  | | 11-8-17 | | |

Location

Loc Qty

Loc Code

MAT20

128

117285

8

118228

120

118228

35

| W/O: | | WORK ORDER CHANGES | | | | | |
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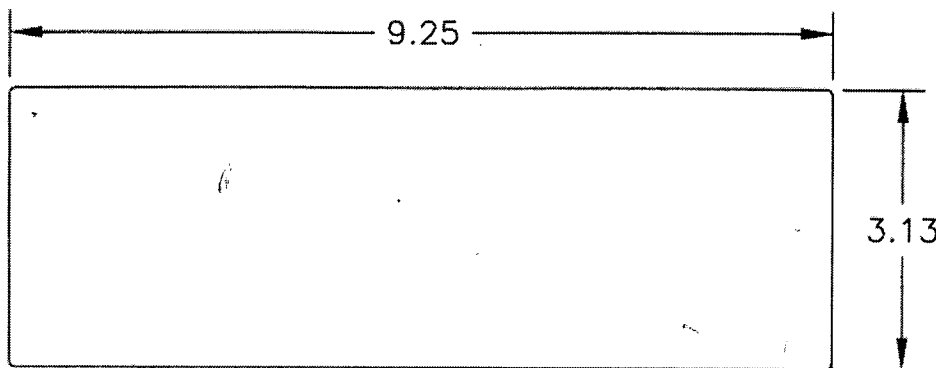
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NOTE: Date & initial all entries



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|------------------|----------------|---|------------------------|
| DESIGN # | DRAWN BY UP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3190 | REV. A SHEET 1 OF 1 |
| DATE 03.05.16 | | TITLE CHAFING SHIELD | SCALE 1:2 |
| A | 03.05.16 | NEW ISSUE | |

RELEASED
03.05.22 #



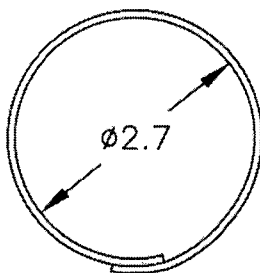
D3190-1 FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72876

R11-08-2.

3.13

R0.063
(TYP)



D3190-1 ROLLING DETAIL
NOT TO SCALE

D3190-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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